



MODEL T10432

ROUTER TABLE w/STAND

OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
FOR MODELS MANUFACTURED SINCE 11/10 #TSJB13636 PRINTED IN CHINA



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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IMPORTANT NOTICE!

Modification Required for Mounting Your Router

The universal phenolic mounting board that is included with the Model T10432 does not have pre-drilled mounting holes to hold your router. This is because different brand routers have different base mounting hole configurations.

To properly use this router table, you will have to drill holes in the mounting board that match the base mounting hole configuration of your router. This procedure will require a drill, the correct size drill bits, and possibly additional fasteners for mounting the router.

Before beginning any modification to the phenolic mounting board, read the entire **SETUP** section in this manual to make sure the person making the modification is capable of performing the required tasks, and to make sure that your router is firmly secured to the router mounting board.

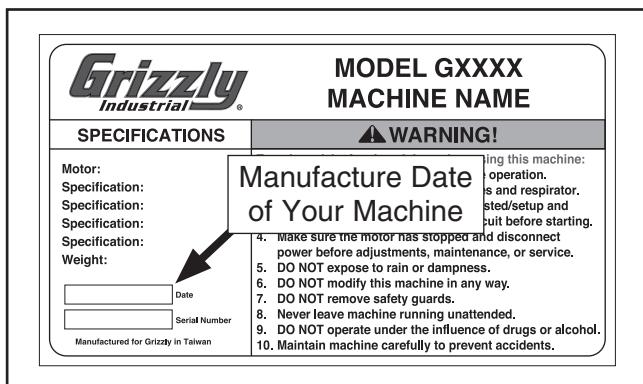
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please gather the model number and manufacture date of your machine. This will help us help you faster.

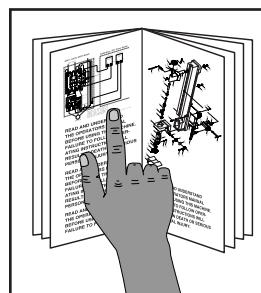
Grizzly Technical Support
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We want your feedback on this manual. Was it helpful? Where could it be improved? Help us help you by taking a minute and letting us know.

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Router table Description

The Model T10432 Router Table includes a sturdy, all-steel stand. The large split-fence boards are adjustable from side to side with a rear-mounted dust port that connects to a shop vacuum or dust collection system. A universal phenolic mounting board with two different sized inserts is included for mounting your router to the table.



WARNING

To reduce the risk of serious injury when using this router table, read and understand this entire manual before beginning any operations.





MACHINE DATA SHEET

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MODEL T10432 ROUTER TABLE W/STAND

Product Dimensions:

Weight	58 lbs.
Table Size (Length/Width)	31½" x 24"
Overall Size (Length/Width/Height).....	32½" x 24¾" x 34½"

Shipping Dimensions:

Type	Cardboard
Weight.....	62 lbs.
Length/Width/Height.....	38" x 26" x 6"

Main Specifications:

Maximum Table Opening Size.....	3¾"
Number of Table Inserts	2
Table Insert Inside Openings.....	1¼", 2½"
Fence Board Size (x 2)	18" x 6"
Number of T-Slots Per Fence Board	1
Number of Table T-Slots.....	1
T-Slot Size	¾" x ¾"
Dust Port Size	2½"

Other Specifications:

Country Of Origin	China
Warranty.....	1 Year
Assembly Time	30 minutes



SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER

Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

⚠WARNING

Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

⚠CAUTION

Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

⚠WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine. Untrained users can be seriously hurt.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

WEARING PROPER APPAREL. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of work-piece control.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lit to minimize risk of injury.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

CHILDREN & BYSTANDERS. Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



WARNING

Additional Safety for Router Tables

AVOIDING AMPUTATION. To avoid making contact with the spinning router bit, never place hands directly over or in front of the bit. As one hand approaches the bit, move it away and over to the other side. Always keep hands at least 6" away from the spinning bit.

SECURING LEVERS AND KNOBS. Never operate the router table without first making sure that all lock levers and knobs are tight, and that all fence hardware and guide rails are secure. Otherwise, the workpiece can slip out of alignment while cutting and cause injury from kickback.

DO NOT FORCE WORKPIECE. Never force materials past the router. Let the router bit do the work. Excessive force is likely to result in poor cutting results and will cause kickback conditions that could cause serious personal injury.

BLIND CUTTING. Keep the router bit on the underside of the workpiece when making blind cuts. This will decrease the risk of accidental contact with the rotating bit.

ROUTER BIT ROTATION. Always feed the workpiece against the rotation direction of the bit. Otherwise, the workpiece could be aggressively pulled from your hands, drawing them into the spinning bit.

ROUTER BIT HEIGHT. Keep any unused portion of the bit below the table surface to minimize the risk of your hand contacting the rotating bit.

APPROPRIATE WORKPIECES. The danger of kickback and injury is increased when the workpiece has knots, holes, or foreign objects in it. Warped stock should be flattened with a jointer before you cut it with the router.

TESTING ROTATION. With the router disconnected from power, rotate the router spindle to test any new setup to ensure proper bit clearance before starting the router.

CUTTING SUPPORT. NEVER cut a workpiece without using a fence, jig, or miter gauge as a support guide. Otherwise, the workpiece could be aggressively pulled from your hands, drawing them into the spinning bit.

WORKPIECE SIZING. NEVER use a workpiece shorter than six inches without special fixtures or jigs. Otherwise, the workpiece can become trapped between the fence and router bit, which could draw your hands into the spinning bit.

USING SAFETY GUARDS. To prevent amputation or other injuries, always use a guard. Fabricate additional guards or jigs for special circumstances. Use an overhead guard if the fence is removed.

TRIPPING HAZARD. To prevent tripping over the power cord of the router when not in use, always disconnect it and safely store it out of the way.

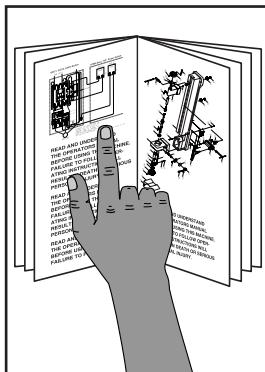
WARNING

Like all machinery there is potential danger when operating this router table. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this router table with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this router table and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: SETUP



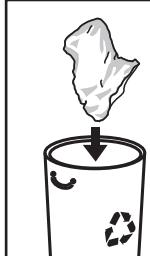
⚠️WARNING

This router table presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before using this router table!



⚠️WARNING

Wear safety glasses during the entire setup process!



⚠️WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials unpacked with this machine. Discard immediately.

Needed for Setup

The following are needed to complete the setup process, but are not included with your router table.

Description	Qty
• Another Person	1
• Wrench or Socket 10mm.....	1
• Wrench or Socket 13mm.....	1

Unpacking

Your router table was carefully packaged for safe transportation. Remove the packaging materials from around your router table and inspect the contents. If you discover the router table is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Inventory (Figure 1)	Qty
A. Router Mounting Board 3 ⁷ / ₈ " ID	1
—Insert 2 ⁵ / ₈ " ID	1
—Insert 1 ¹ / ₄ " ID	1
B. Fence Support	1
C. Fence Boards	2
D. Guard	1
E. Table	1
F. Fence Scale Tapes	2
G. Rubber Feet	4
H. Long Bottom Stand Braces 27 ¹ / ₄ "	2
I. Long Top Stand Braces 20 ¹ / ₂ "	2
J. Short Bottom Stand Braces 19 ³ / ₄ "	2
K. Short Top Stand Braces 15 ³ / ₄ "	2
L. Dust Port Housing	1
M. Stand Legs 33"	4
N. Dust Port 2 ¹ / ₂ "	1

NOTICE

If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.

O. Hardware (Not Shown):

- Hex Bolts M6-1 x 18 (Table/Braces) 4
- Fender Washers 6mm (Table/Braces) 4
- Carriage Bolts M8-1.25 x 10 (Stand) 32
- Flat Washers 8mm (Stand) 32
- Hex Nuts M8-1.25 (Stand) 32
- Hex Bolts M8-1.25 x 25 (Fence) 6
- Flat Washers 8mm (Fence) 6
- Star Knobs M8-1.25 (Fence) 6
- T-Bolts M6-1 x 25 (Guard) 2
- Flat Washers 6mm (Guard) 2
- Tri-Knobs M6-1 (Guard) 2
- Phillips Head Screws M5-.8 x 55 2
- Starting Pin 1
- Hex Wrench 3mm 1

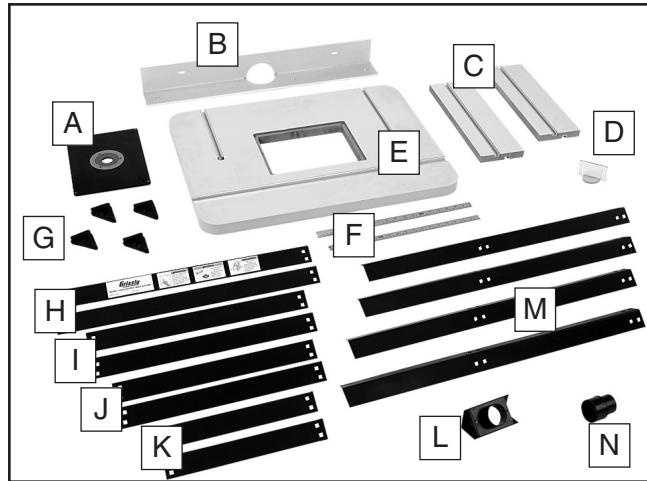


Figure 1. Model T10432 inventory.

Assembly

To assemble the router table:

1. Turn the table upside down on a protective surface, then attach the (2) long top stand braces to the table with (4) M6-1 x 18 hex bolts and 6mm fender washers, as shown in **Figure 2**.

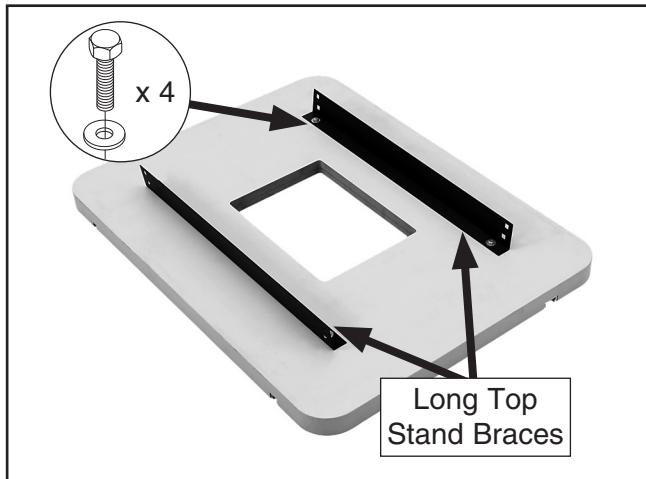


Figure 2. Long top stand braces attached to the underside of the table.

2. Attach each stand leg to a long and short top brace with (16) M8-1.25 x 10 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts, as shown in **Figure 3**.

Note: For now, hand-tighten the stand fasteners. In a later step, the stand will be squared up and the fasteners fully tightened.

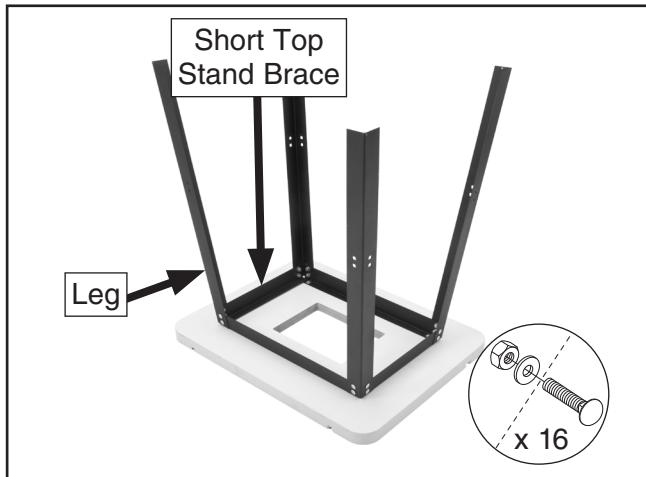


Figure 3. Stand legs and short top stand braces attached.

3. Attach the long bottom stand braces to the legs with (8) M8-1.25 x 10 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts, as shown in **Figure 4**.

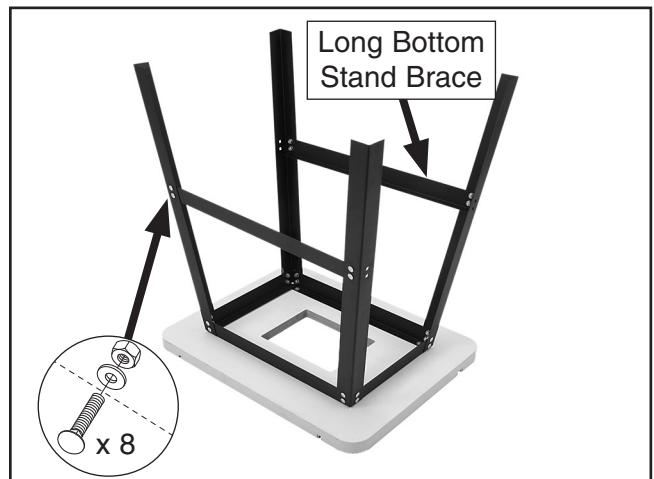


Figure 4. Long bottom stand braces attached.

4. Attach the short bottom stand braces with the remaining (8) M8-1.25 x 10 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts, as shown in **Figure 5**.

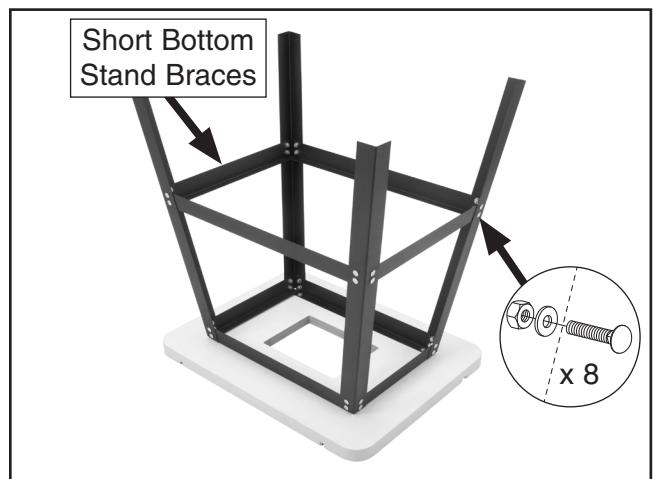


Figure 5. Short bottom stand braces attached to the legs.

5. Install the (4) rubber feet onto the ends of the legs. Turn the stand and table assembly over, square up the stand, then fully tighten all the fasteners.

6. Slide (2) M8-1.25 x 25 hex bolts into the table T-slots, place the fence support over the bolts, then secure it in place with (2) 8mm flat washers and M8-1.25 star knobs, as shown in **Figure 6**.

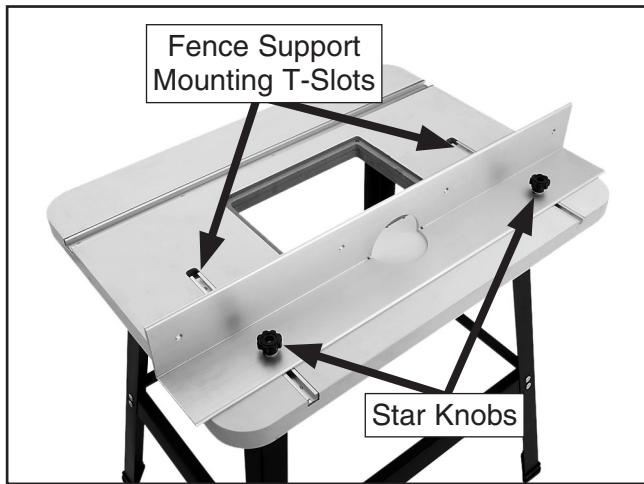


Figure 6. Fence support attached to the table top.

7. Peel the adhesive from the scale tapes, then apply them to the tops of the fence boards.

Note: When installing the fence boards in the next step, make sure the 0" ends of the tapes are nearest the center of the table.

8. Slide the heads of (4) M8-1.25 x 25 hex bolts into the fence board T-slots, insert the bolts through the holes in the fence support, then secure the fence boards with (4) 8mm flat washers and M8-1.25 star knobs, as shown in **Figure 7**.

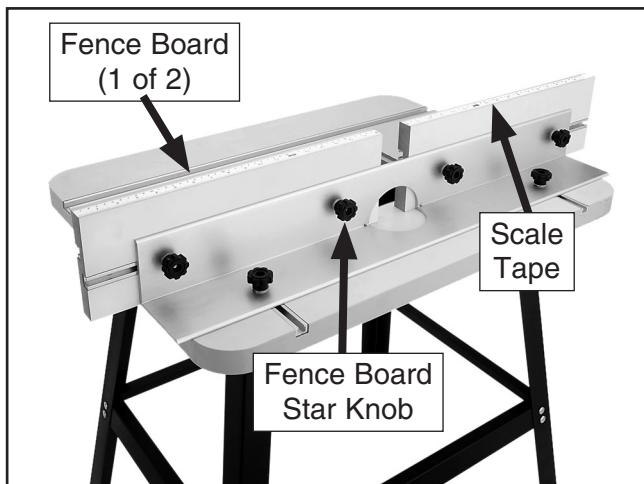


Figure 7. Fence boards secured to the fence support.

9. Slide the heads of the (2) M6-1 x 25 T-bolts into the T-slots on the fence board faces, position them towards the center, slide the router guard over the bolts, then secure it in place with the (2) 6mm flat washers and M6-1 tri-knobs, as shown in **Figure 8**.

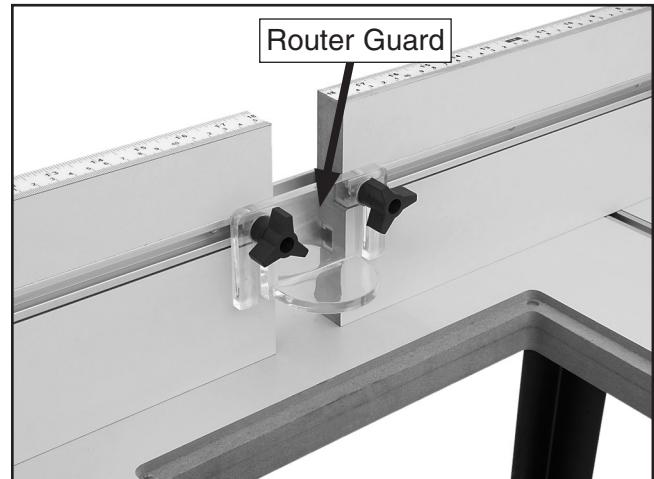


Figure 8. Router guard installed.

10. Slide the dust port onto the dust port housing, then attach the assembly to rear of the fence support with the (2) M5-8 x 55 Phillips head screws, as shown in **Figure 9**.

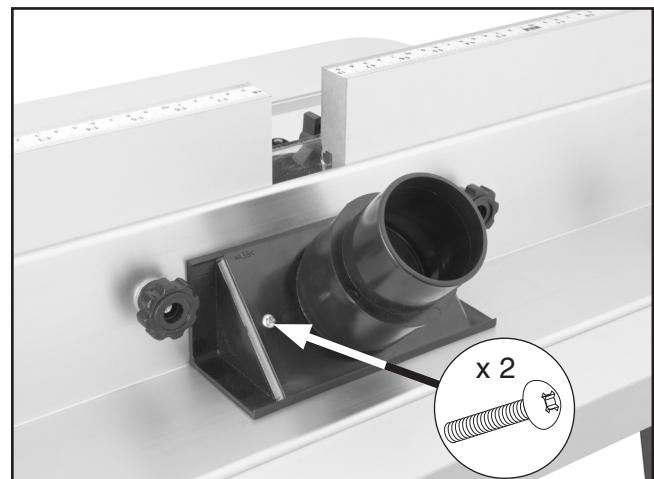


Figure 9. Dust port assembly attached to the fence support.

! CAUTION

DO NOT operate the attached router without an adequate dust collection system. Follow your router manufacturer's specifications for the required dust collection capacity. Failure to use a dust collection system can result in short and long-term respiratory illness.



Router Installation

The phenolic router mounting board included with the router table is designed to attach to the bottom of your router in the same manner as the router base.

To complete this installation, you will need a drill, drill bit(s), and fasteners. We recommend using the router base as a template for the hole pattern to be drilled in the mounting board.

Important: When deciding how to orient the router in relation to the router table, take into account access to the router controls, such as depth adjustment knobs, lock levers/knobs, and the power switch.

To install your router onto the mounting board:

1. DISCONNECT ROUTER FROM POWER!
2. Insert the mounting board into the router table so that the starting pin holes are to the right of the opening, as shown in **Figure 10**.

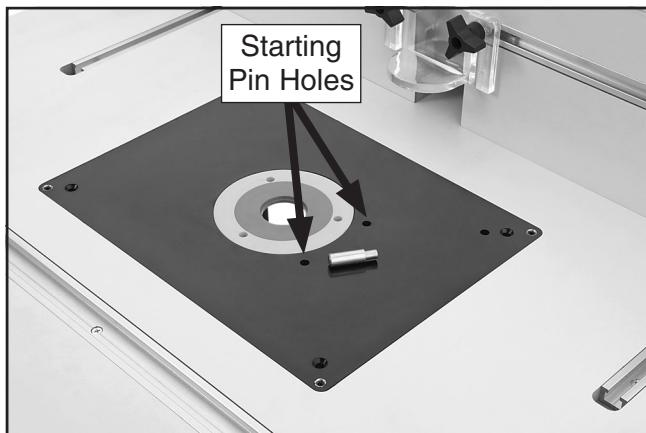


Figure 10. Proper location of the starting pin holes.

3. Mark the front of the mounting board with tape or other removable substance.
4. Turn the router upside down and position it so that it is facing you in the same orientation that it will face the front of the router table.

5. Make marks on the base and the router to guide you when mounting the router so that it will correctly face the front of the router table.
6. Remove the router base from the router.
7. Turn the router table mounting board upside down, center the router base on the board so that the marks locating the front of each match.
8. Use the mounting holes in the router base as a template to mark the holes for drilling the holes in the mounting board (see **Figure 11** for an example).

Note: There are multiple circles in the underneath surface of the mounting board to aid in centering the router base as a template.

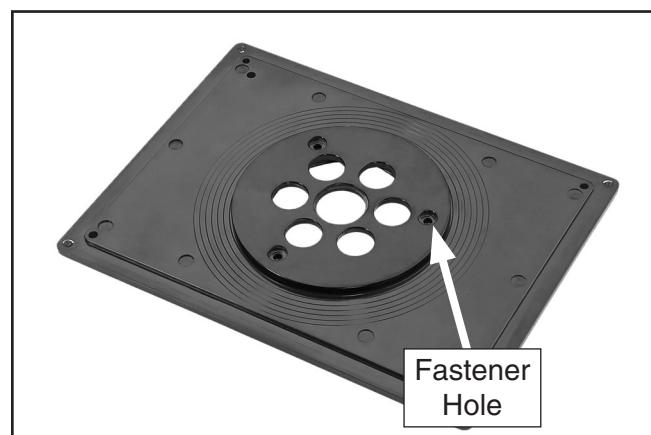


Figure 11. Example of using the router base as a template to drill mounting holes.

WARNING

If the router unexpectedly moves or the router bit contacts the table insert or fence during operation, serious personal injury could result from the router bit or flying debris. **ALWAYS** make sure that the router is firmly secured to the router table mounting board before beginning operation.

9. Remove the router base from the mounting board, drill the correct size holes in the mounting board for the fasteners.



10. Make countersinks in these holes from the top of the mounting board so that the fasteners will be slightly below the top surface of the board. This will prevent the workpiece catching on the fasteners during operation.
11. Turn the router upside down with the mark you made in **Step 5** facing you.
12. Position the mounting board, top surface up, so that the mark you made on it in **Step 3** is facing you and the mounting holes in the board are aligned with those in the router.
13. Fasten the mounting board to the router (see **Figure 12**), then insert the assembly into the router table from the top.



Figure 12. Example of a router attached to the router table mounting board.

Aligning Router Mounting Board

To ensure that a workpiece does not catch on the mounting board or table insert and cause a kickback hazard, the board and inserts must be aligned even with the table surface.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Straightedge 24"	1

To align the router mounting board and table inserts even with the table:

1. DISCONNECT ROUTER FROM POWER!
2. Remove the fence assembly from the table.
3. Lay the straightedge across the router mounting board and table inserts in a star pattern (see **Figure 13**) so that both ends are over the table.

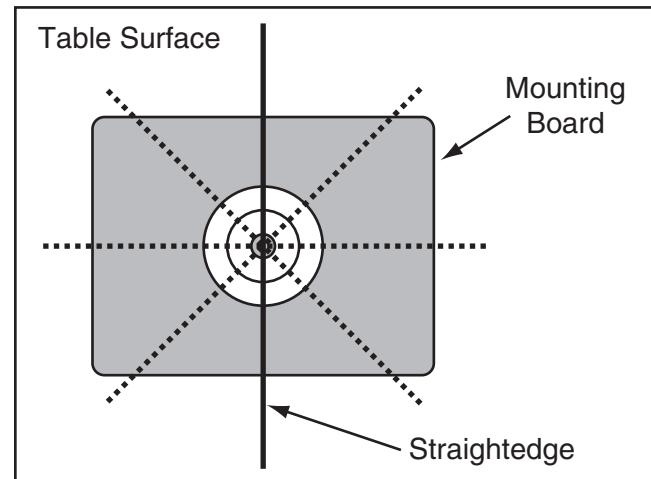


Figure 13. Star pattern for the straightedge when aligning the mounting board with the table.

4. Adjust the set screws at the corners of the mounting board (see **Figure 14**) until the ends of the straightedge lay flat on the table surface at all positions of the star pattern.

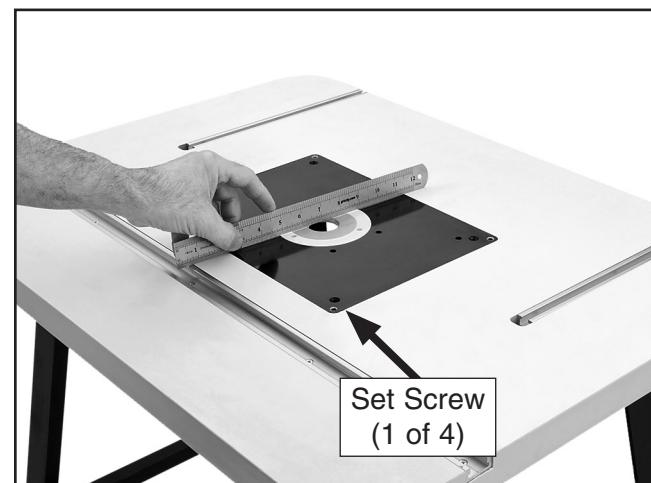


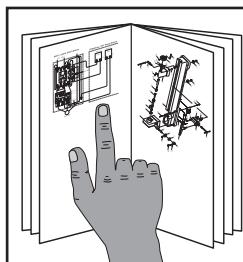
Figure 14. Using the straightedge on the mounting board and table.

SECTION 3: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

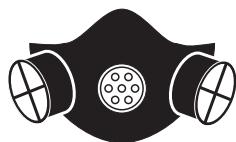
Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



WARNING
To reduce the risk of serious injury when using this machine, read and understand this entire manual before operating.

WARNING

Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.



NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence boards close to the bit for maximum workpiece support, then secures the fence boards in place.
3. Adjusts the bit height for the desired cutting profile.
4. Adjusts the fence position to establish the depth of cut and makes sure that it is parallel with the table T-slot.
5. Wears safety glasses and a respirator. Locates push sticks or blocks if needed.
6. Verifies that the direction of router bit rotation is correct for the operation, and then starts the router.

Important: For smaller workpieces or odd-shaped workpieces, a zero-clearance fence or jig is used.

7. Holds the workpiece firmly and flatly against the table and fence, then pushes the workpiece into the bit at a steady and controlled rate until the workpiece moves completely beyond the router bit.

Important: The operator is very careful to keep the workpiece firmly against the table and fence and hands away from the rotating router bit, during the entire cut.

8. Stops the router.



Workpiece Inspection

Some workpieces are not safe to cut or may require modification before routing. Before routing, inspect all workpieces for the following:

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While routing, these objects can become dislodged and hit the operator, cause kickback, or break the bit, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots may dislodge during a cutting operation. Knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Routing wood with a moisture content over 20% causes unnecessary wear on the router bits, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being shaped. DO NOT process workpieces with these characteristics unless you properly square up the stock with a jointer and planer.
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. A workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

! CAUTION

To avoid workpiece kickback or binding when using a miter gauge with this router table, **ALWAYS** make sure the fence boards are parallel with the table T-slot before beginning operation.

Squaring Fence & Table

When using a miter gauge, it is important to make sure the fence boards are parallel to the table T-slot. This will help ensure that the workpiece does not bind or kickback during operation. Use a fine ruler to make the distance between the fence boards and the T-slot equal along the full length of the table (see **Figure 15** for an example).

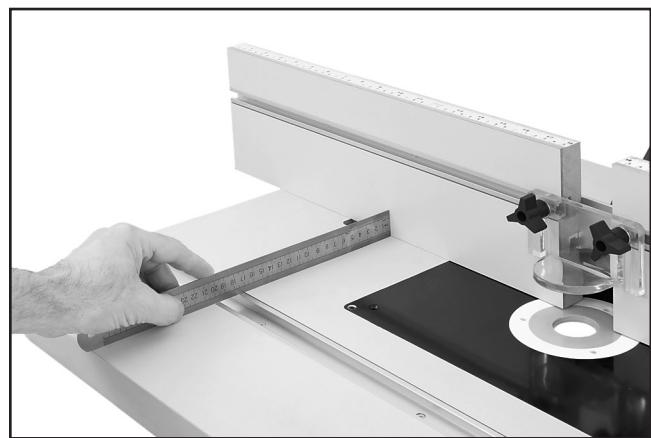


Figure 15. Adjusting the fence parallel with the table T-slot.

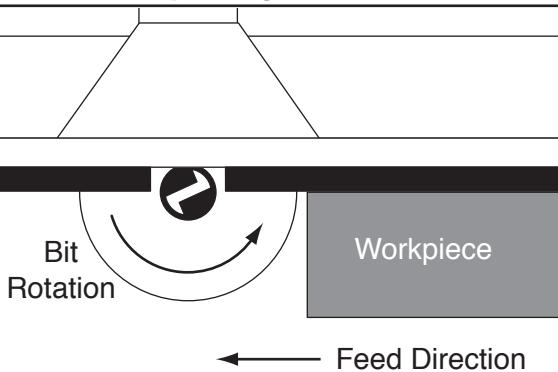


Edge Jointing

Jointing the edge of a board involves using a straight cutting router bit to remove wood from the face of the board. The result is a perfectly flat and square edge.

WARNING

Always feed the workpiece against the router bit rotation direction, as illustrated below. Otherwise, the workpiece could be aggressively pulled from your hands, drawing them into the spinning router bit.



To joint the edge of a workpiece:

1. DISCONNECT ROUTER FROM POWER!
2. Secure a straight cutting bit into your router according to the router manufacturer's instructions.
3. Install the smallest table insert in the router table that allows the router bit to freely rotate.
4. Raise the bit just above the top of the workpiece, then rotate it by hand until the cutting flute is perpendicular to the fence boards.
5. Secure a shim between the outfeed fence board and fence support. The thickness of the shim controls the amount of material removed with each pass. (see the illustration in **Figure 16**).

Important: To reduce the risk of kickback, do not take more than $\frac{1}{8}$ " off for any one pass.

Top View

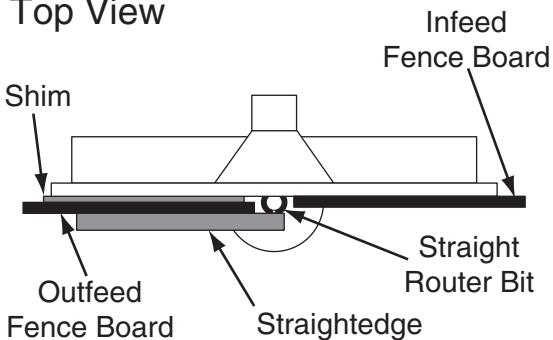


Figure 16. Fence setup for edge jointing (guard removed for clarity).

6. Place a straightedge against the outfeed fence board, then adjust the fence assembly so that the straightedge is also against the bit flute, as illustrated in **Figure 16**.
7. Make sure the fence boards are parallel with the table T-slot, lock the fence assembly in place, and tighten all knobs.
8. Connect the router to power, then perform the cut (see **Figure 17**).

Top View

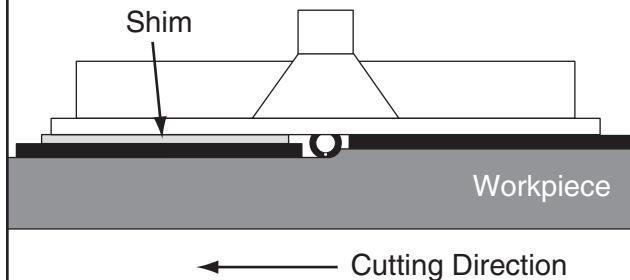


Figure 17. Edge jointing (guard removed for clarity).

CAUTION

To reduce the risk of hand injury from accidental contact with the spinning router bit, **ALWAYS** make sure the fence and router guard are properly positioned and secured before connecting the router to power (does not apply to free hand-hand routing).



Profile Routing

To cut a profile into the workpiece:

1. DISCONNECT ROUTER FROM POWER!
2. Secure the bit into the router according to the router manufacturer's instructions.
3. Install the smallest table insert into the table that still allows the bit to freely rotate.
4. Raise the bit to the desired height, then adjust the fence assembly so the fence boards are behind the bit the same distance as the desired depth-of-cut (see the illustrations in **Figures 18–19**).

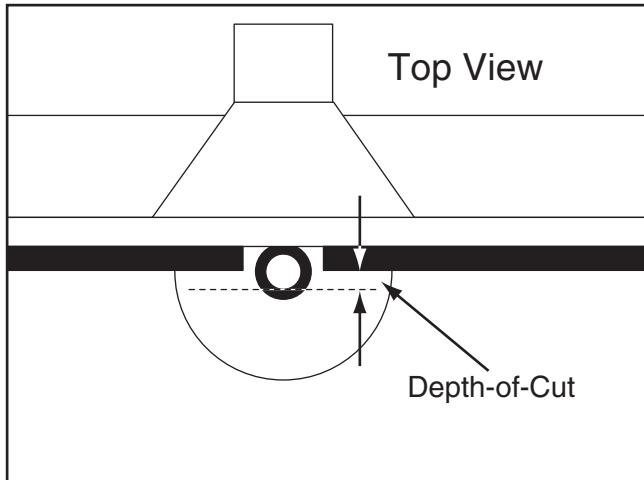


Figure 18. Groove cutting setup, top view (guard removed for clarity).

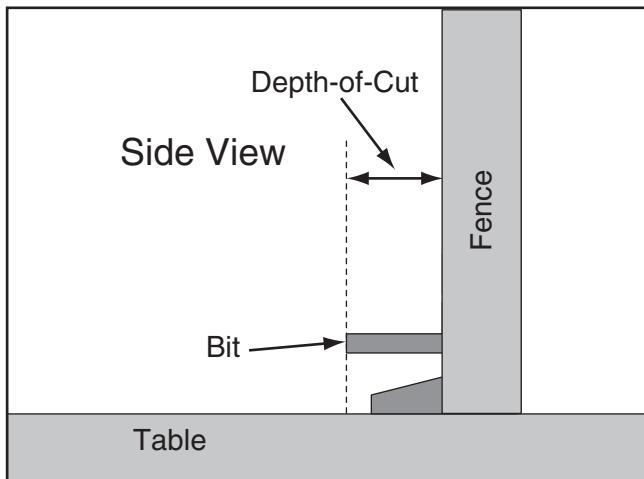


Figure 19. Groove cutting setup, side view (guard removed for clarity).

5. Make sure both fence boards are even with one another and the table T-slot.
6. Lock the fence assembly in place, tighten all knobs, connect the router to power, then perform the cut.

Routing Small Stock

Feeding small stock past the router bit increases the risk of kickback from the workpiece slipping into the space between the fence and bit. If you must route small stock, use a zero-clearance fence. This will provide greater protection for the operator, better workpiece support, and reduced tear out on narrow or fragile stock.

To make a zero-clearance fence:

1. DISCONNECT ROUTER FROM POWER!
2. Remove the fence boards from the fence support.
3. Select a piece of straight and smooth stock that is the same height and thickness as the fence boards and approximately 36" long.
4. Cut an outline of the spindle and router bit from the center of the stock selected in **Step 3**, as illustrated in **Figure 20**.

Note: Make the outline as close as possible to the router bit and spindle without interfering with rotation.

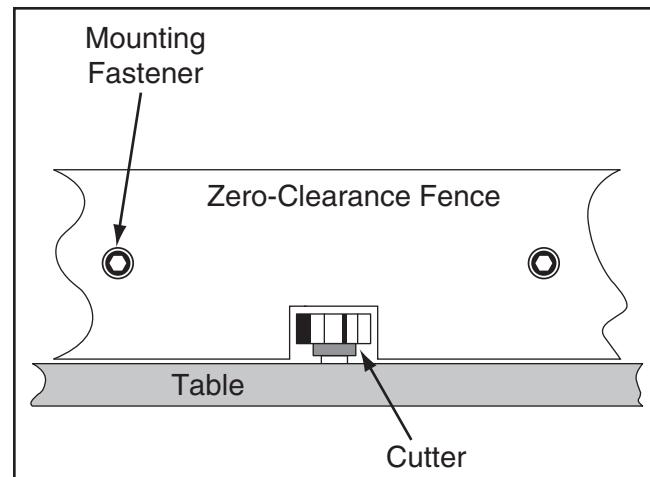


Figure 20. Example of a zero-clearance fence.



5. Create countersunk mounting holes in the zero-clearance fence so the bolts, flat washers, and star knobs removed from the fence boards can be used to secure the new fence to the fence support in the same manner.

! CAUTION

ALWAYS use hold-downs or featherboards and push sticks when shaping small or narrow stock. These devices keep your hands away from the spinning router bit and sufficiently support the stock to allow a safe and effective cut, reducing the risk of personal injury.

6. Secure the zero-clearance fence to the fence support, then make sure the fence is parallel to the table T-slot.
7. Check for proper clearance, connect the router to power, then make a test cut to verify the results.

Free-Hand Routing

Irregular or free-hand routing, as illustrated in **Figure 21**, takes a high degree of skill and dexterity and is done without the protection and aid from the fence and guard. The most dangerous part of free-hand routing is beginning the cut, when the router bit first contacts the workpiece. Often the workpiece will tend to jerk or kickback, presenting an injury hazard to the operator.

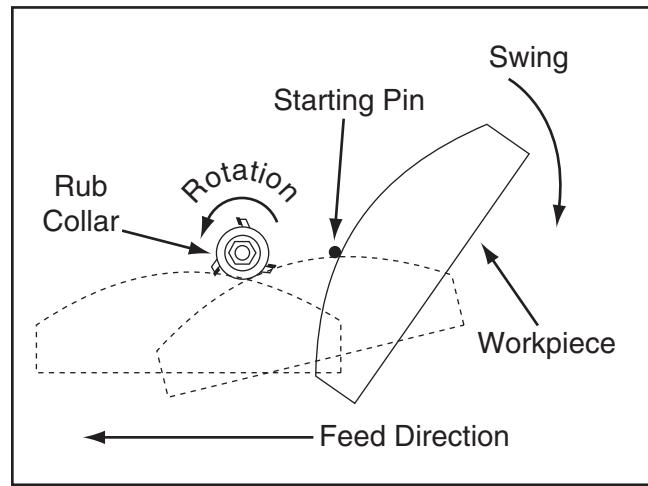
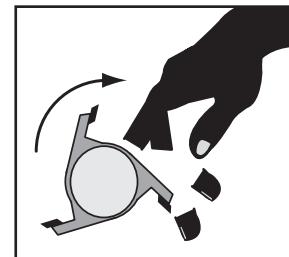


Figure 21. Illustration of free-hand routing using a starting pin (guard not shown for clarity).

! WARNING



Free-hand or irregular routing greatly increases the chance that the operator may lose control of the workpiece, which could result in serious personal injury. Therefore, a starting pin or block and a custom guard or workpiece holding jig **MUST** be used.



To reduce the likelihood of kickback when free-hand routing, use the starting pin or block (see **Figures 21–22** for examples). This will allow you to anchor and slowly pivot the workpiece into the bit as the cut is started, making the operation more stable and safe.



Figure 22. Generic picture of using a jig with a starting block (guard removed for photo clarity).

⚠️WARNING

ALWAYS use an auxiliary jig and extreme care when free-hand routing. Routing without the fence and the attached guard greatly increases the risk of accidental contact with the spinning router bit, causing serious personal injury.

To free-hand route:

1. DISCONNECT ROUTER FROM POWER!
2. Fabricate a jig to use with the workpiece that will match the desired finished shape, then attach it to the workpiece (see **Figure 22** for an example).

Note: Make sure any fasteners used will not make contact with the router bit during the cutting operation. Hot glue can be used as an alternative.

3. Remove the fence assembly from the table.
4. If possible, fabricate and mount a custom guard over the bit that safely protects your hands from the spinning router bit.
5. Insert the starting pin in the best suited hole on the routing table or clamp a starting block to the table (see **Figure 22** for a generic picture).
6. Install a router bit with a bearing guide as directed by the router manufacturer's instructions, then raise it to the desired height (see **Figure 23**).

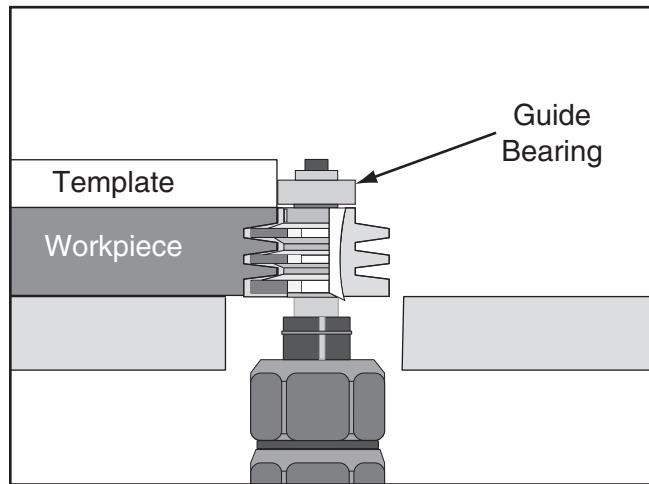
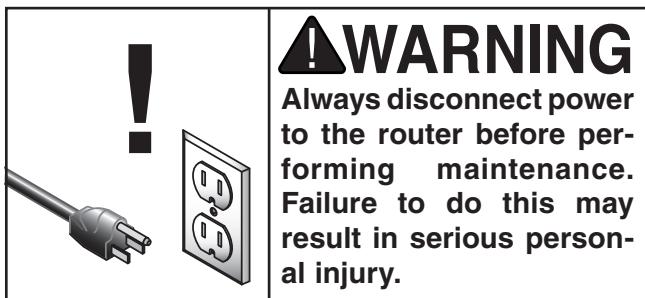


Figure 23. Using a template and rub collar for free-hand routing.

7. Rest the workpiece against the starting pin, then slowly pivot and feed the workpiece into the bit. After the cut is started, move the workpiece against the guide bearing and away from the starting pin.

SECTION 4: MAINTENANCE



Schedule

For optimum performance from your equipment, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

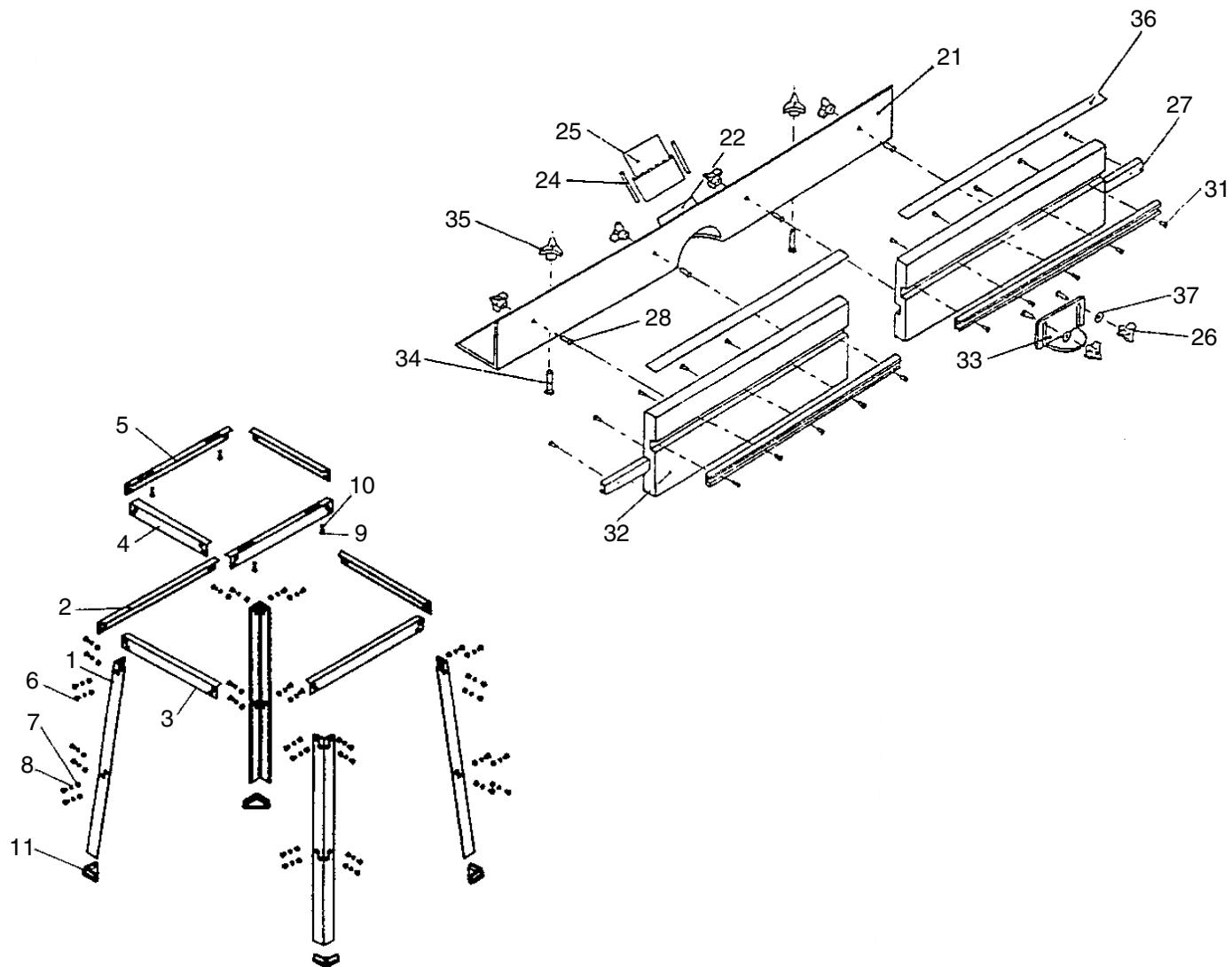
- Loose mounting T-bolts or lock knobs.
- Worn router switch.
- Loose stand fasteners.
- Loose router mounting fasteners.
- Worn or damaged router cords and plugs.
- Any other condition that could hamper the safe operation of this router table.

Cleaning & Protecting

Frequently vacuum sawdust and wood chips from the table and router, then blow off the remaining dust with compressed air. This is especially important for the internal working parts of the fence assembly and the router. Dust build-up around the router is a sure way to decrease its life span.

SECTION 5: PARTS

Stand & Fence Parts



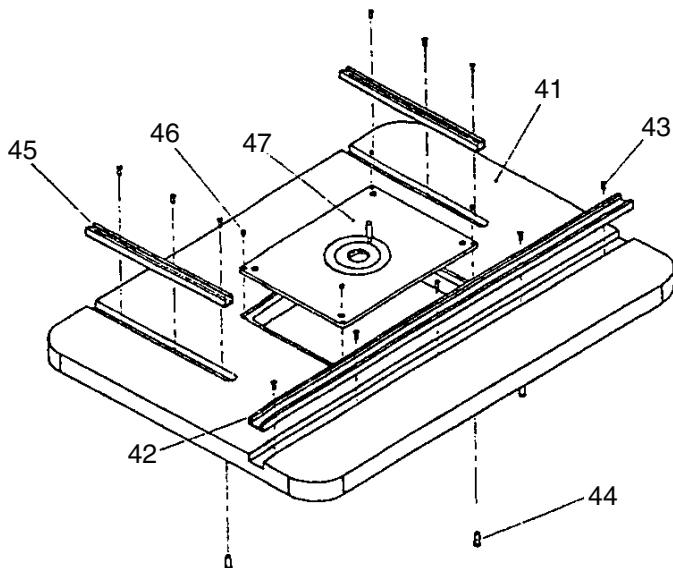
REF PART # DESCRIPTION

1	PT10432001	LEG
2	PT10432002	LONG LOWER CROSS BRACE
3	PT10432003	SHORT LOWER CROSS BRACE
4	PT10432004	SHORT UPPER CROSS BRACE
5	PT10432005	LONG UPPER CROSS BRACE
6	PCB11M	CARRIAGE BOLT M8-1.25 X 12
7	PN03M	HEX NUT M8-1.25
8	PW01M	FLAT WASHER 8MM
9	PB83M	HEX BOLT M6-1 X 16
10	PW03M	FLAT WASHER 6MM
11	PT10432011	RUBBER FOOT
21	PT10432021	FENCE BRACKET
22	PT10432022	DUST PORT ADAPTER

REF PART # DESCRIPTION

24	PS51	PHLP HD SCR 10-24 X 2-1/4
25	PT10432025	DUST PORT
26	PT10432026	KNOB 1/4-20
27	PT10432027	MITER SLOT TRACK
28	PB05	HEX BOLT 1/4-20 X 3/4
31	PHTEK38	TAP SCREW #4 X 1/2
32	PT10432032	FENCE
33	PT10432033	GUARD
34	PB11	HEX BOLT 5/16-18 X 1-1/2
35	PT10432035	KNOB 5/16-18
36	PT10432036	SCALE
37	PW06	FLAT WASHER 1/4

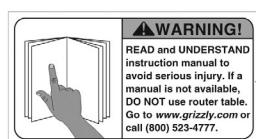
Table Parts & Labels



51



55



54



53



52

REF PART # DESCRIPTION

41	PT10432041	TABLE TOP
42	PT10432042	MITER SLOT TRACK 32"
43	PHTEK38	TAP SCREW #4 X 1/2
44	PN05	HEX NUT 1/4-20
45	PT10432045	MITER SLOT TRACK 11-3/4"
46	PSS02M	SET SCREW M6-1 X 6

REF PART # DESCRIPTION

47	PT10432047	INSERT W/GUIDE PIN 9 X 12
51	PT10432051	ID LABEL
52	PT10432052	AMPUTATION HAZARD LABEL
53	PLABEL-57C	GLASSES/RESPIRATOR LABEL HS
54	PLABEL-12D	READ MANUAL LABEL HS
55	PPAINT-7	BLACK TOUCH-UP PAINT







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 Journal of Light Cont.
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 RC Modeler
 Rifle
 Shop Notes
 Shotgun News
 Today's Homeowner
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 Woodshop News
 Woodsmith
 Woodwork
 Woodworker West
 Woodworker's Journal
 Other:

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 \$60,000-\$69,000

\$40,000-\$49,000
 \$70,000+

4. What is your age group?

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 50-59

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 60-69

40-49
 70+

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6. How many of your machines or tools are Grizzly?

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7. Do you think your machine represents a good value? Yes No

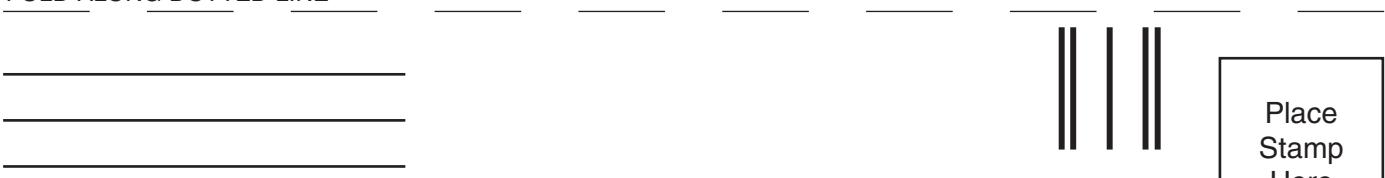
8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

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